AS800 PRESSURE SEALER OPERATING INSTRUCTIONS

CONTENTS

SECTION

Machine Specification Sheet
1.1.1 Technical Specification
1.1.2 Control Panel Layout
1.1.3 Button Explanation
1.1.4 Machine Layout Diagram

1.2.1 Machine Setup and Operation
1.2.2 Hand-feed Operation
1.2.3 Clearing a Document Jam
1.2.4 Double Document Condition
1.2.4 Supervisor Mode

1.3.1 Operator's Troubleshooting Guide
1.3.2 Operator Maintenance

1.4.1 Display Panel Error Messages

MACHINE SPECIFICATION SHEET

1. ***CAUTION:*** In order to ensure correct safety and operation, this machine must be installed and maintained by an authorised Service Engineer.

2. ***CAUTION:*** Should any cover or safety interlock be damaged, the machine must not be used until service repairs have been completed.

3. ***CAUTION:*** **This machine must be earthed**. The wire colours in the mains cord are:
(Green 110v) (Green/Yellow 220/240V) which must be connected to Earth (Ground).
(White 110v) (Blue 220/240v) which must be connected to Neutral.
(Black 110v) (Brown 220/240v) which must be connected to Live (Line).

4. ***CAUTION:*** This machine must not be used if the mains cord becomes damaged. It must be replaced with a similar mains cord:
(Part No. 141-162-321 U.S.). (PFE Part No. 162-210 U.K.).
(PFE Part No. 162-311 EURO).

5. ***CAUTION:*** For continued protection against risk of fire, replace with same type and rating of fuse. The fuse rating and type for this machine is :
T 3.15 A Amps 220/240Volts (PFE Part No. 141-135-103).
T 6.3 A Amps 110Volts (PFE Part No. 141-135-106).

6. **Model Details:**

Model Name: Pressure Sealer

Model Number: AS800

Input Voltage:	220/240 Volts @ 50 Hz	Input Voltage:	110 Volts @ 60 Hz
Input current:	2 Amps	Input current:	4 Amps
Input Power:	480 Watts	Input Power:	480 Watts

Sound Reading: 75dBA
(measured at a distance 1 metre from the nearest cover and 1.6 metres from the ground)

7. The use for this machine is pressure sealing documents.

8. The weight of this machine is: 176 kgs. (unpackaged)
210 kgs. (packaged, with accessories)
Lifting or handling must only be carried out by competent persons using appropriate means.

Distributor and Service contact:

IMPORTANT NOTICE

Before connecting the machine to a power source,
please read the Machine Specification Sheet opposite.
Ensure that the power cord is undamaged.

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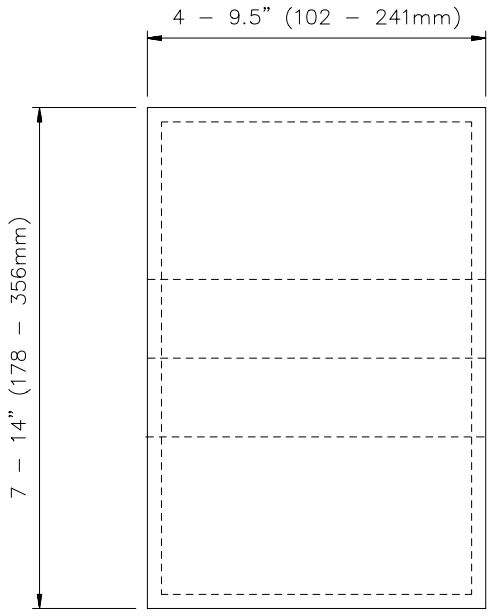
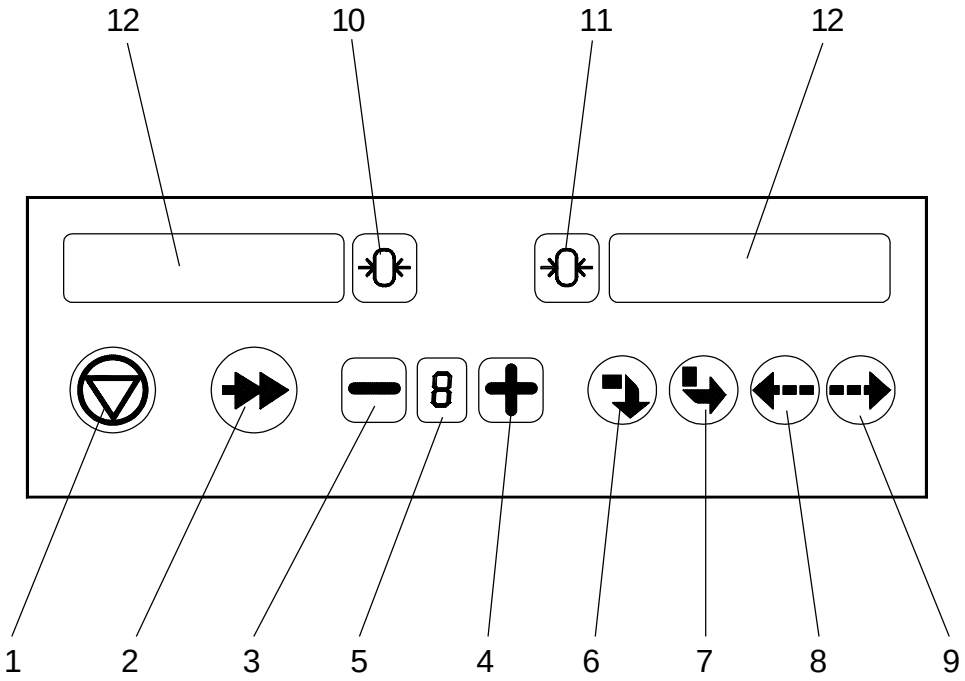
1.1.1 TECHNICAL SPECIFICATION

Machine type	Low volume pressure sealer
Speed	Variable, up to 6000 documents per hour
Volume to a maximum of:	7,000 documents per day
	21,000 documents per week
	1 million documents per year

Document dimensions (folded flat):



1.1.2 CONTROL PANEL LAYOUT



1. Stop button
2. Start button
3. Speed decrease button
4. Speed increase button
5. Speed indicator
6. Setup button
7. Hand feed button
8. Jog reverse button
9. Jog forward button
10. Zero reset (in-count) button
11. Zero reset (out-count) button
12. Display panels

A detailed description of each button function is given in the following section.

1.1.3 BUTTON EXPLANATION

1. **Stop button:** Allows documents currently passing through machine to continue to output, then halts operating cycle.

2. **Start button:** Starts machine into continuous running, and also cancels any errors which may be indicated after the cause of the problem has been cleared by the operator.

3. **Speed decrease button:** Decreases speed in steps down to 0, shown on speed indicator display.

4. **Speed increase button:** Increases speed in steps up to 9, shown on speed indicator display.

5. **Speed indicator:** Indicates speed in steps from 0 to 9 (max.)

6. **Setup button:** Feeds through a single document in order to calibrate document length and weight. This is for double document detection. Document is diverted before sealing to enable fold lengths to be checked.

7. **Hand feed button:** Allows single document to be fed through pressure rollers. Note: document must be pre-folded by hand, and placed in folder bypass chute.

8. **Jog reverse button:** "Jogs" document back through machine in small steps. Used for clearing jams. Note: after operating, there is a 2 second pause before button can be operated again.

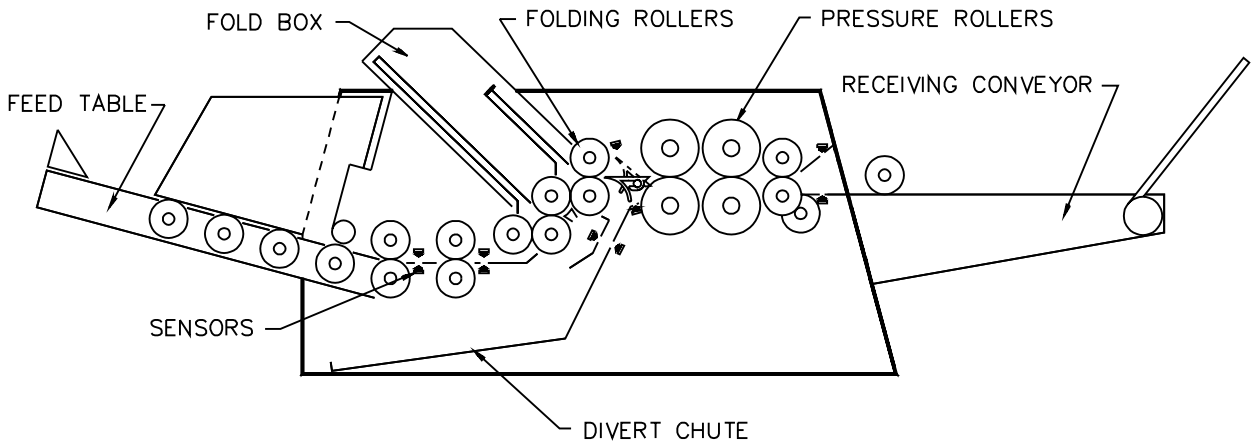
9. **Jog forward button:** "Jogs" document forward through machine in small steps. Used for clearing jams. Note: after operating, there is a 2 second pause before button can be operated again.

10. **Zero reset (in-count) button:** Zeroes counter display for documents fed in (machine must be stopped). Note: count will maintain until zero reset is pressed, even when machine is stopped or switched off.

11. **Zero reset (out-count) button:** Zeroes counter display for documents fed out (machine must be stopped). Note: count will maintain until zero reset is pressed, even when machine is stopped or switched off.

12. **Display panels:** Displays in or out count, and also error messages.

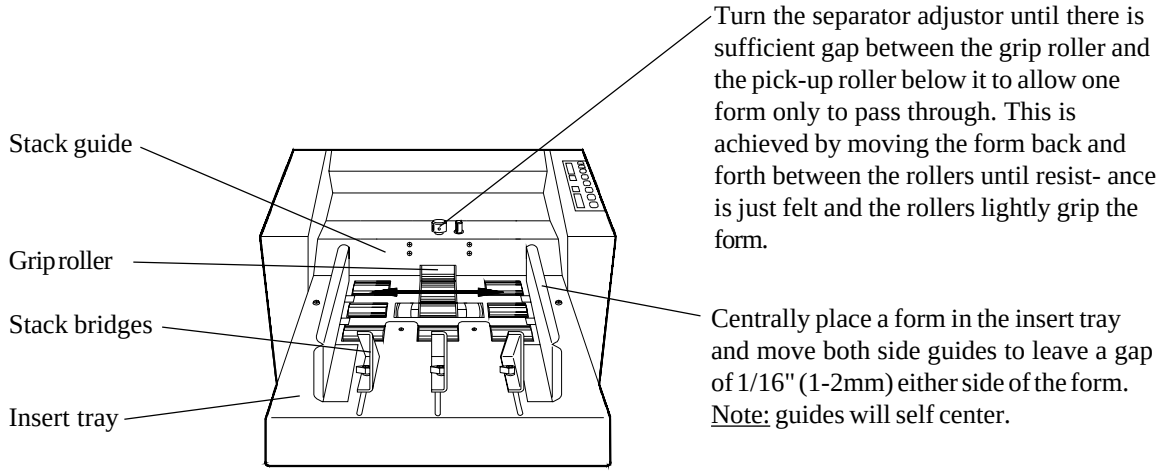
1.1.4 MACHINE LAYOUT DIAGRAM



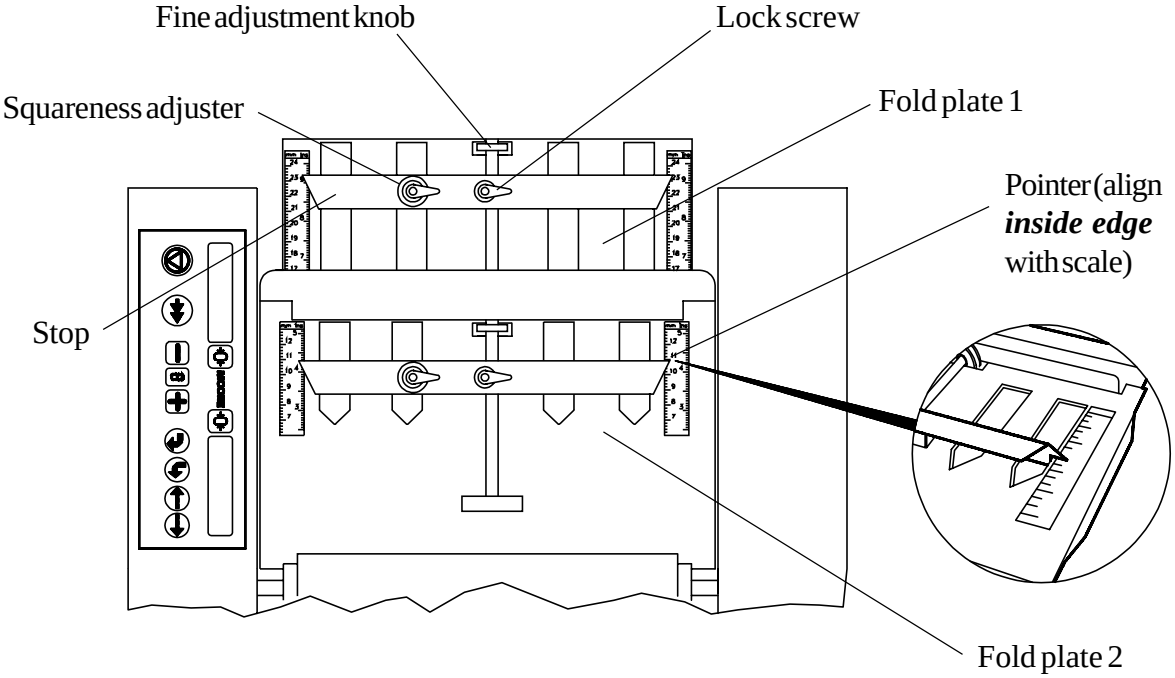
1.2.1 MACHINE SETUP AND OPERATION

1. Plug in machine, switch on at power switch and release emergency stop button.

2. Adjust the separator gap to suit the document form, as shown below.


Stack guide
Grip roller
Stack bridges
Insert tray
Turn the separator adjustor until there is sufficient gap between the grip roller and the pick-up roller below it to allow one form only to pass through. This is achieved by moving the form back and forth between the rollers until resist- ance is just felt and the rollers lightly grip the form.
Centrally place a form in the insert tray and move both side guides to leave a gap of 1/16" (1-2mm) either side of the form.
Note: guides will self center.

3. Establish fold type and length required, raise the folder cover and set the fold plates as described below:



The fold plate stops are adjusted by loosening the lock screws, sliding the stop to the required position as indicated by the pointer against the scale, and retightening the lock screws. A fine adjustment is provided by turning the knob shown. This will adjust the fold position by small amounts if a running test shows this to be needed.

Additionally, the squareness of the stop can be adjusted by loosening the squareness adjuster lock screw and turning the knurled cam knob below it. This may be required if running tests reveal that the documents are being folded 'skewed'. Retighten the lock screw after any adjustment is made.

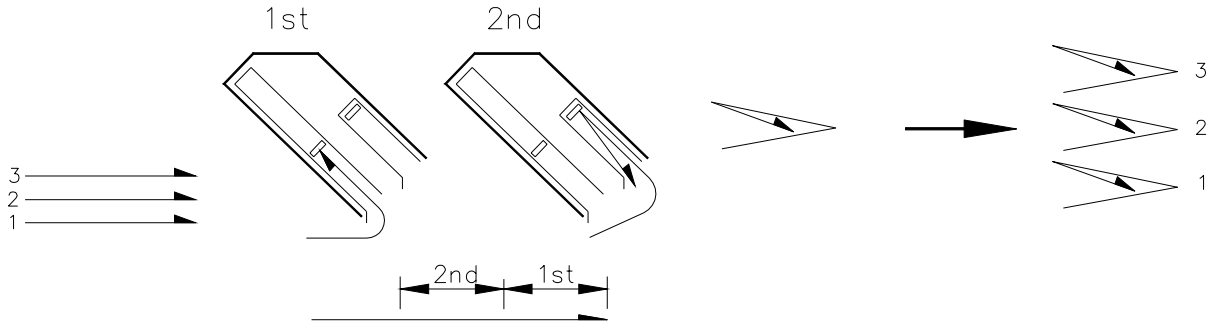
The scales accord with the exact measured position of the required fold on the document, and the ***inside edge*** of the pointer is aligned with the scale measurement (see diagram on previous page). For example, if the first fold is required at 4" (102mm) down from the leading edge of the document, set fold plate 1 at this position. The crease then becomes the leading edge for the second fold position, so if the second fold is required at 4½" (114mm) from the crease, set fold plate 2 at this position. Note that if the squareness adjuster has been moved at any time, the pointer position will change, and this will have to be compensated for when measuring fold positions. Running tests will reveal to what extent.

The fold plates are removable and are retained by clips. If the document requires only a single center fold, slide out fold plate 2. Turn it round the other way and also turn it over, then slide it back into position. This then acts as a blanking plate and the document will bypass it. Set the stop of fold plate 1 to half the length of the document.

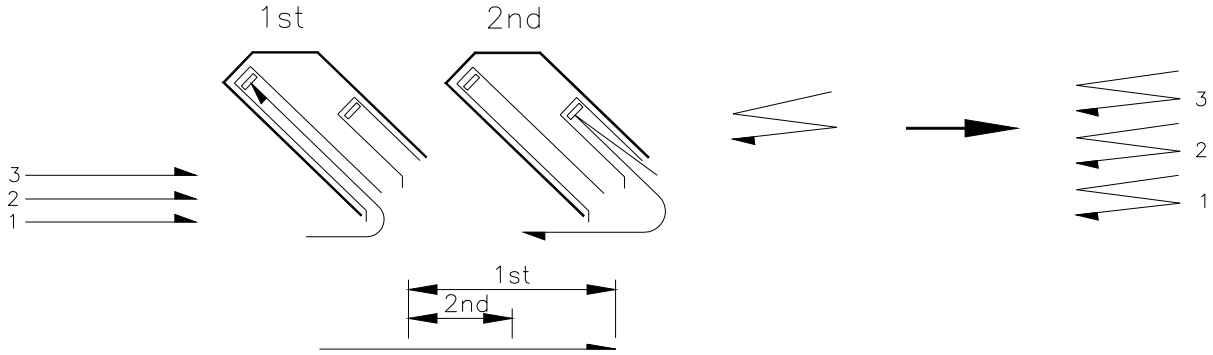
The three types of fold which may be used are shown overleaf:

Below are shown the three types of fold which may be used:

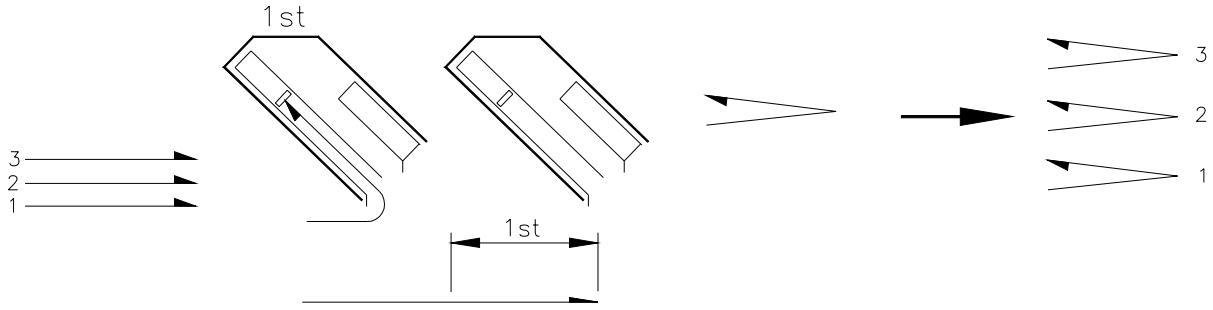
1. Letter (or Wallet) Fold



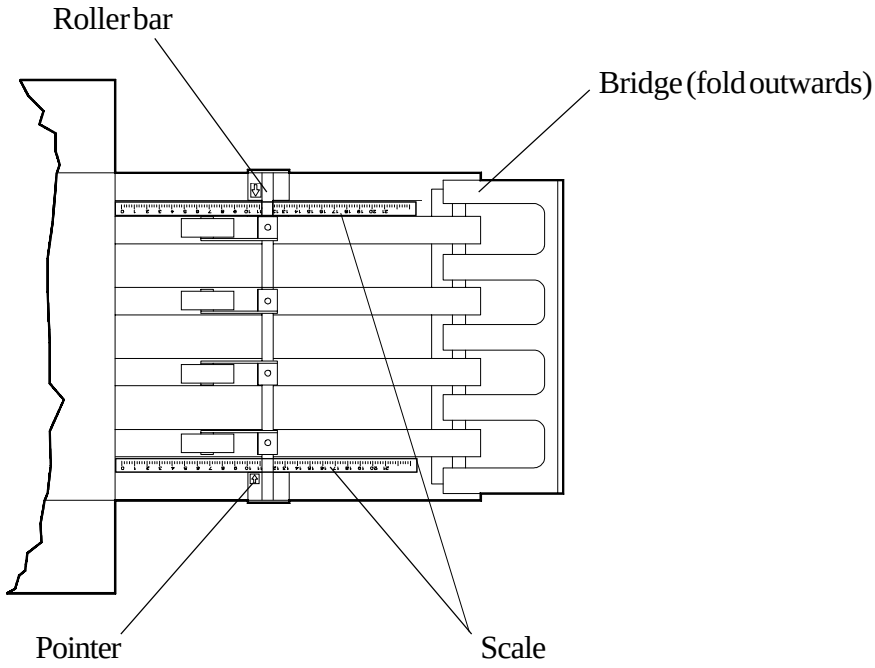
2. Accordian (or 'Z') Fold



3. Single (or Half) Fold



4. Set the output conveyor rollers and bridge as shown below:

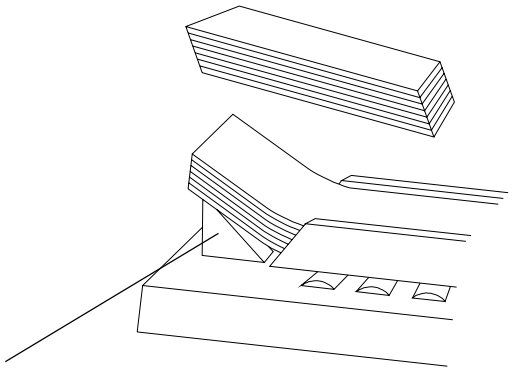


Fold the bridge outwards to provide a stop for the accumulating stack of forms. Slide the roller bar to align the pointer with the measurement on the scale that accords with the finished length of the folded and sealed document. In most cases this is the same as the length of the second fold.

5. When setting up for the first time, load one document and press the setup button to begin calibration cycle. A message CONF CAL on the display panel will request confirmation that you wish to calibrate. Press again to confirm. A message CAL will be momentarily displayed and the document will be fed. The double document and form length sensors will measure the length and average thickness of the document. This will act as a gauge for all future documents of that size, and hence is only done once until the document size is changed. The gauged document will be ejected via the divert chute. At the end of a successful calibration cycle, a message CAL PASS will be displayed. In the event of a calibration failure, the relevant error message will be displayed. (See section 1.4.1).

Note: If the 'Auto-calibrate' DIP switch on the CPU circuit board has been set, the machine will automatically enter the setup mode either after power-up or when re-starting after hopper empty condition. Setting of the switch is not an Operator function - it must be set by a Customer Service Engineer.

6. Place a stack of documents in the insert tray. Forms must be orientated according to fold type and print direction. Ensure that the leading edges of the stack of forms are against the stack guide.



Adjust the stack bridges to support the backs of the forms. Further re-adjustment may be required for reliable feeding.

7. Set the required speed using the (speed increase) or (speed decrease) buttons. The speed increments in steps 0-9, as shown on the indicator panel between the two buttons. The speed may be varied whilst machine is running.

8. Now that form calibration, fold plates and speed are all set, press the start button and the documents will begin feeding. Note that the count of the documents fed in and fed out is displayed on the left and right display panels respectively

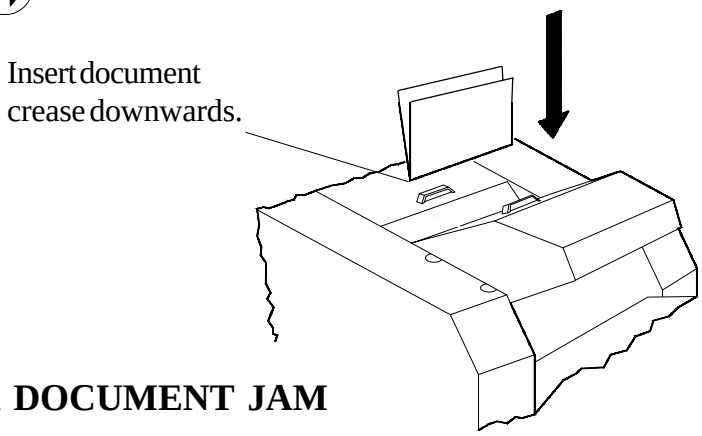
When the run of documents has finished, either or both of the count displays may be zeroed by pressing 'in count' or 'out count' buttons

9. When the document run has finished (or the feeder tray runs out) the machine will stop operating after about 3 seconds and the message Error FA1 will show on the display. Press the stop button to clear the display.

NOTE: IN THE EVENT OF ANY EMERGENCY, OR TO STOP THE MACHINE FOR ANY OTHER REASON, PRESS THE RED EMERGENCY STOP KNOB ADJACENT TO THE CONTROL PANEL

1.2.2 HANDFEED OPERATION

If required, a single document may be hand fed for sealing only. First fold the document as desired (see previous section) and place it in the folder bypass chute immediately in front of the folder cover. Press the handfeed button and the folded document will pass through the sealing rollers.



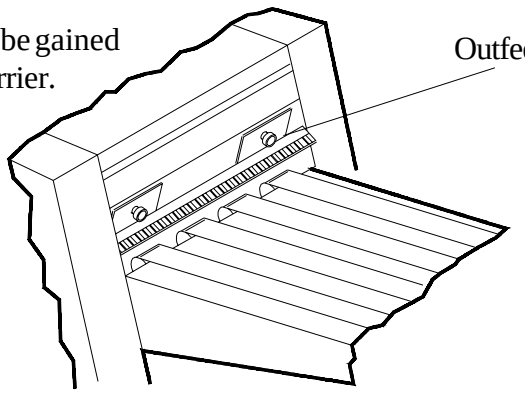
1.2.3 CLEARING A DOCUMENT JAM

A document jam may be caused by a number of conditions, such as a damaged or crumpled edge, incorrect fold etc. Whatever the cause, a jam will result in the machine stopping automatically, and an error message will be shown on the display panel.

To free the jammed document, switch the machine off, raise the folder and feed roller covers to ascertain the position of the jammed form. This will determine whether the form should be moved forwards or backwards to clear the rollers for retrieval. Close the covers, switch back on and press the jog forward or jog backwards buttons as required. This will operate the machine in short, slow 'spurts' to clear an edge of the damaged document. Raise the covers again and pull the freed document out. It may be necessary to repeat this operation more than once until the damaged document is fully clear.

NOTE: THE MACHINE WILL NOT RUN WITH THE COVERS OPEN, DUE TO SAFETY MICROSWITCHES

Access to the outfeed roller area can be gained by removing the guide/static brush carrier. Replace before running machine.



1.2.4 DOUBLE DOCUMENT CONDITION

If more than one document is fed at one time, such as if two are stuck together, they will not pass through the sealing rollers, but will be diverted to the divert chute. The machine will stop, and an error message Error FA3 will appear on the display. The diverted document can be retrieved from the divert chute opening at the rear end of the machine. This is the default condition.

The machine can also be set for an alternative double document condition. In this mode, when a double document is fed, it will be directed to the divert chute and the machine will carry on operating normally. The diverted document will not register on the count display. If a second double document is then fed immediately afterwards, the machine will stop and the error message Error FA3 will appear on the display. This alternative mode is selected via a DIP switch on the CPU board, and should only be set by a Customer Service Engineer.

Note that in both modes, pressing the start button will restart the machine and clear the display, which will then revert back to document count.

If several double documents occur in a short space of time, the cause should be investigated. It may be that that the separator is incorrectly set (see section 1.2.1, para 2) or that the stack of documents needs 'rifling' for proper separation.

1.2.5 SUPERVISOR MODE

The Supervisor Mode will allow the display of the total machine running time to date. The total forms count to date can also be displayed. Press the stop and jog-forward buttons simultaneously to enter the mode. Successful entry into the mode will be confirmed by the display: SUP INFO

Press the jog-forward button again to show the total hour count to date (to within 1/10th hour) in the following format on the display: Hour HHHH.H

Press the jog-forward button again to show the total forms count to date as a ten-digit number in the following format on the display: nnnnn nnnnn

Press the jog-forward button again to cycle back to the SUP INFO display.

Press the stop button to exit Supervisor Mode.

1.3.1 OPERATOR'S TROUBLESHOOTING GUIDE

1. Documents not feeding.

Possible cause:	Possible remedy:
Separator gap incorrectly set	Adjust separator as in section 1.2.1, para. 2

2. Slow feeding of documents

Possible cause:	Possible remedy:
Feed rollers need cleaning	Clean all rubber rollers as in section 1.3.2

3. Documents jam in folder.

Possible cause:	Possible remedy:
i) Side guides incorrectly set	i) Reset side guides
ii) Documents incorrectly stacked	ii) Check forms and re-stack
iii) Curled or damaged edges on document	iii) Remove damaged documents

4. Documents incorrectly folded.

Possible cause:	Possible remedy:
i) Fold lengths set too long or short	i) Re-measure fold lengths and re-adjust as shown in section 1.2.1, para. 3
ii) Side guides set too wide	ii) Reset side guides
iii) Documents out of square ('skewed')	iii) Adjust squareness of stop as shown in section 1.2.1, para. 3

5. Documents not sealing

Possible cause:	Possible remedy:
i) Defective adhesive on document	i) Test documents from a different batch
ii) Sealing rollers incorrectly set	ii) Contact service department

6. Repeated double document condition

Possible cause:	Possible remedy:
i) Separator gap incorrectly set	i) Adjust separator as in section 1.2.1, para. 2
ii) Documents sticking together	ii) 'Rifle' document stack

contd.

7. Double documents fail to divert

Possible cause:	Possible remedy:
i) Documents jamming in diverter	i) Check edges of documents for curling or damage
ii) Diverter not working	ii) Solenoid malfunction - contact Service Dept.

8. Double document will not set

Possible cause:	Possible remedy:
Documents already held in hold point	Open covers and remove offending document. If necessary, use 'jog' buttons as described in section 1.2.3

9. Documents jamming on output conveyor

Possible cause:	Possible remedy:
Roller position on conveyor set incorrectly	Reset roller as shown in section 1.2.1, para. 4

10. Bad folding or jamming in folder

Possible cause:	Possible remedy:
Folder rollers need cleaning	Clean folder rollers as in section 1.3.2

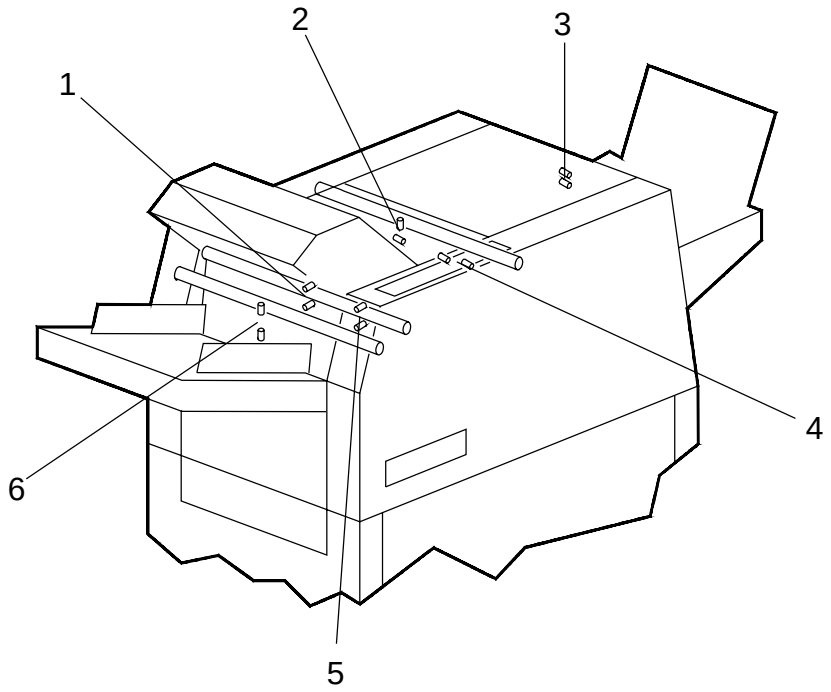
11. Error message showing on display panel when there are no documents in machine

Possible cause:	Possible remedy:
i) Dirty sensors	i) Clean all sensors. Refer to sections 1.3.2 for sensor positions
ii) Cover(s) not properly closed	ii) Check both top covers are fully closed

1.3.2 OPERATOR MAINTENANCE

After a period of running, especially if the machine is heavily used, the sensors will tend to become obscured with paper dust. This may lead to erratic operation of the machine, and so the sensors must be regularly cleaned. This particularly applies if the machine appears to be malfunctioning in any way, and cleaning of the sensors should always be carried out before alerting the Service Department of any faults. The sensors should always be cleaned before starting a long continuous machine run.

The locations of the sensors are illustrated below:



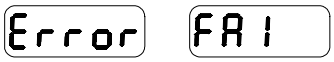
1. Folder Input Sensors
2. Folder Output Sensors
3. Output Sensors
4. Divert Sensors
5. Doubles Detect Sensors
6. Folder Hold Point Sensors

ROLLER CLEANING

At the same time that the sensors are cleaned, all visible rubber rollers and feed wheels should also be cleaned. Ensure that the roller and wheels are cleaned round their full circumference.

1.4.1 CONTROL PANEL ERROR MESSAGES

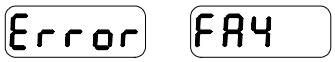
If any of the following error messages occur, do not attempt to continue the run, but switch off the machine and take the remedial action stated. If this or any other obvious solutions do not clear the fault, the service department must be contacted.



Documents not being fed. This message occurs if no document is fed after about 3 seconds, such as if the feed tray is empty.

Hand-feed load has failed. May be caused by incorrect insertion of the document into the hand-feed chute.

Double document feed has occurred. Separator gap may be incorrectly set, or documents need 'rifling'.



Attempt to divert a double document has failed, and document has passed through sealing rollers instead. Diverter solenoid may be stuck.

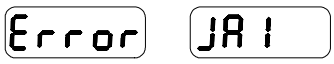
Folder input sensor blocked. If no visible obstruction, sensor may require cleaning.

Folder exit sensor blocked. If no visible obstruction, sensor may require cleaning.

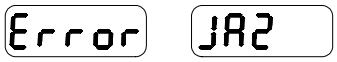
Divert sensor blocked. If no visible obstruction, sensor may require cleaning.

Ouput sensor blocked. If no visible obstruction, sensor may require cleaning.

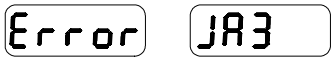
contd.



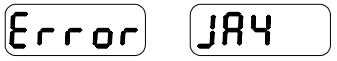
Diverter has actuated, but document has not passed through. Document may be damaged and stuck in diverter.



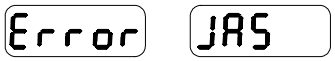
Document jammed in feeder rollers. Clear jam before continuing.



Document jammed in folder rollers. Clear jam before continuing.



Document jammed in sealer rollers. Clear jam before continuing.



Document jammed on conveyor. Clear jam before continuing.

The following messages indicate a machine fault, rather than an operating fault.

Folder cover open

Sealer roller cover open.

Motor has failed to start. Contact the Service Department.

Motor has stalled. Contact the Service Department.

Motor has failed to stop. Contact the Service Department.

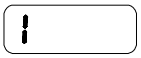
contd.

Of the following three messages in the left hand display panel, any of the five messages shown below may occur in the right hand display.

Unexpected arrival at a sensor. Remove all documents passing through machine and restart cycle. If message still occurs, con- tact the Service Department.

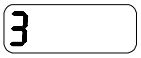
Unexpected departure from a sensor. Remove all documents passing through machine and restart cycle. If message still occurs contact the Service Department.

Document tracking failure. Remove all documents passing through machine and restart cycle. If message still occurs, contact the Service Department.

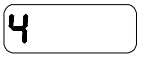


Pertaining to folder input sensor.

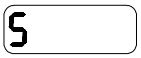
Pertaining to folder output sensor.



Pertaining to roller sensor.



Pertaining to hold point sensor.



Pertaining to divert sensor.